

Work Order ID 60032

June 23, 2010 8:35:57 AM



Page 1

Item ID: D2197-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 6/23/10

Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: CL

Date: 10/6/23 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2197

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Debur if necessary

304-063

FB 10-6-23

(1)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 10-6-23

120

QC8- Inspect parts - second check

0.00



QC

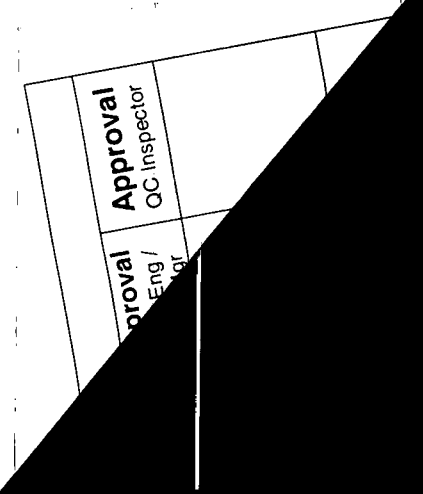
Memo

0.00

Quality Control

8/10/06/23

(H)



W/O:			WORK ORDER CHANGES				
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	App Chief Prod M

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Item Name: Bracket

Start Date: 6/23/10

Start Qty: 1.00

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Required Date: 6/25/10

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Customer:





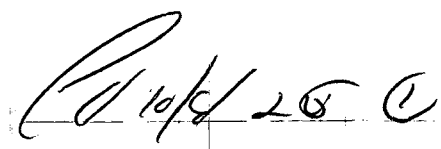
Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Bend as per dwg D2196	0.00 0.00		SB	10/06/24				
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S	10/06/24				
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>1A</u> Memo	0.00 0.00							

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2197-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 6/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28

C210/6/25

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 23, 2010 8:35:57 AM

Page 1

Work Order ID: 60032



Parent Item: D2197-1



Parent Item Name: Bracket

Start Date: 6/23/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA		Purchased	No			100	sf	77.7900	0.1388	0.146105			
-----------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



304/316 Sheet .063



18 10-6-23

Location

Loc Qty

Loc Code

MAT

77.79

111323

0

114799

77.79

114799

①

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60032
Description: Bracket		Part Number:	D2197-1
Inspection Dwg: D2197 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.134				
Ø0.203	+0.005/-0.001	.207				
Ø0.257	+0.006/-0.001	.261				
0.300	+/-0.010	.302				
0.375	+/-0.010	.372				
0.500	+/-0.010	.502				
1.200	+/-0.010	1.197				
2.390	+/-0.010	2.385				
3.280	+/-0.010	3.277				
4.480	+/-0.010	4.481				
4.980	+/-0.010	4.977				
0.500	+/-0.010	.500				
0.813	+/-0.010	.815				
1.750	+/-0.010	1.752				
2.688	+/-0.010	2.682				
3.625	+/-0.010	3.631				
4.000	+/-0.010	4.002				
0.063	+/-0.010	.060				

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-6-03	Date: 10-6-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	[Signature]



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2197	REV. C SHEET 1 OF 1
DATE 03.05.28	TITLE BRACKET		SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2197-3 NOW 0.5" THICK	

RELEASED
03.07.09

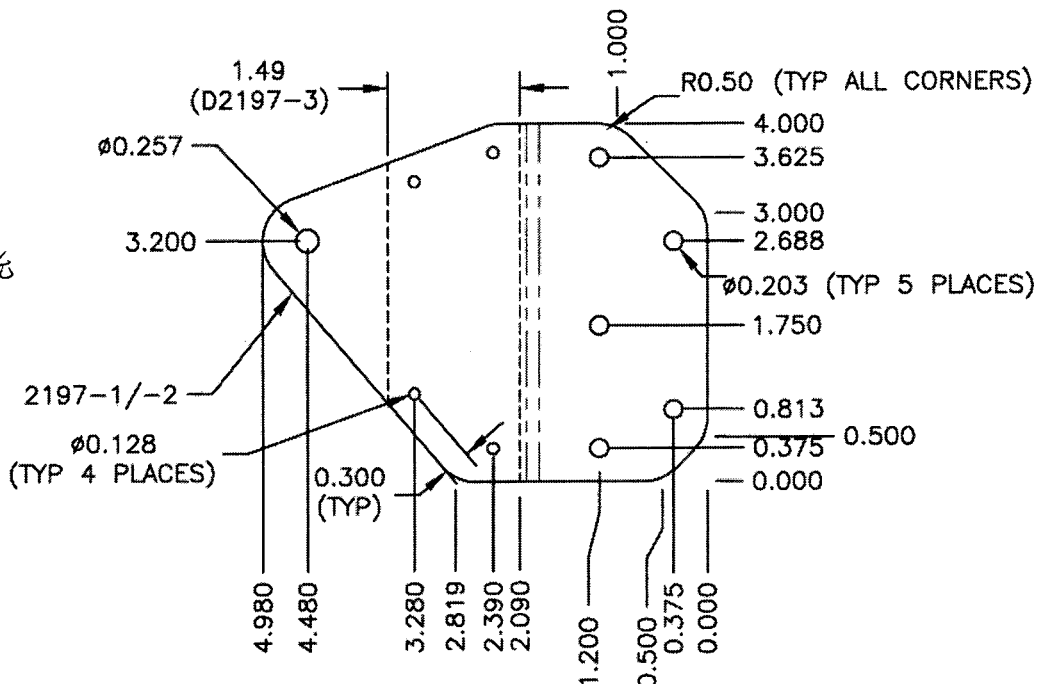
UNDER REVIEW

03.11.12

NCR 08-110

OK 10.06.28

D2197-1/-2/-3
FLAT PATTERN



D2197-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2197-3

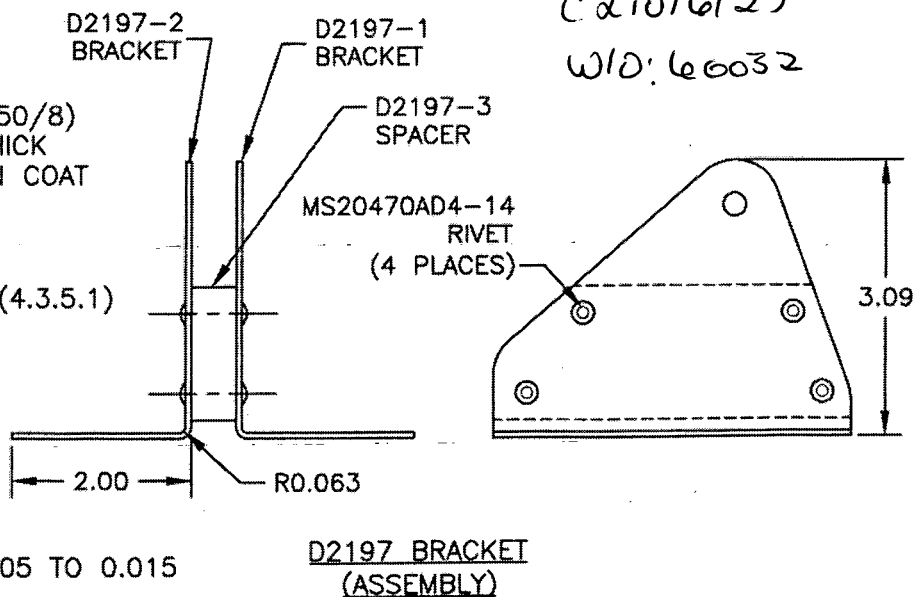
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK OR 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2197 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



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